

9206-628-022 Blue

Dart Aerospace Ltd.

24

Date: Wednesday, 5/16/2007 1:30:10 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, RH
Job Number	: 32392A	Part Number	: D2724042
Estimate Number	: 11703	Drawing Number	: D2724 REVC
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 5/16/2007	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 6/12/2007
Previous Run	: 32250A	Qty:	4 Unit: Each
Written By	: [Signature]		
Checked & Approved By	: [Signature]		
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number: [Barcode]

Seq. #:	Machine Or Operation:	Description:
1.0	D2622120C	Extrusion
	[Barcode]	[Barcode]
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)		
	Qty Part # Description	Batch
	1 D2622-120C Extrusion	B31984
Check Material for any Dents or Defects		
		FF 07-05-31

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	[Barcode]	[Barcode]
Comment: LARGE FABRICATION RESOURCE 1		
Cut D2724-2 using D2622 extrusion as per Dwg D2724		
Deburr and bevel ends for welding		
		R.M. 07-05-31

3.0	D2734	206 Step Endplate
	[Barcode]	[Barcode]
Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)		
	206 Step Endplate	
	Pick:	
	Qty Part Number Description	Batch
	2 D2734 End Cap	B24340
		RE 07-05-31

4.0	D34581	PLATE
	[Barcode]	[Barcode]
Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)		
	Pick:	
	Qty Part Number Description	Batch
	2 D3458-1 Plate	B34073
		RE 07-05-31

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Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 32392A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2

D3458-3

Plate

332481=6
331074=2

J.E. 07-05-31

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig
DT (One End Only)

A/R AL ROD Batch: MIC 2756
MIC 3317

Grind end cap welds flush

a.m. 07/06/04 (4)

J.E. 07-06-04
J.E. 07-06-04
J.E.

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

RH 07/06/05 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-06-05 (4)
RH

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m. 07-06-07 J.E. 7

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-06-07 (4)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

J.E. 07-06-11

Date: Wednesday, 5/16/2007 1:30:10 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 32392A

Part Number: D2724042

Job Number:



Seq. #: Machine Or Operation: Description:

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig
DT
A/R AL ROD Batch: *M102756*

J.E. 07-06-11

Grind end plate flush.

FL id 07-06-12

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/13 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20613 (RH)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

(1)

Touch up Alodine

M.L. 07/06/16 1

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Atelier Debassage

-PRIME

-PAINT DELFLEET BLUE (PER QSI005)

-CLEAR DELFLEET

P.O. 4034 C207/06/25 (1)

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

206-22 (1)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5.4.4

M104733 FL 07/06/25 (1)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

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Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 32392A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 32392

20.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

Done 5/16/06

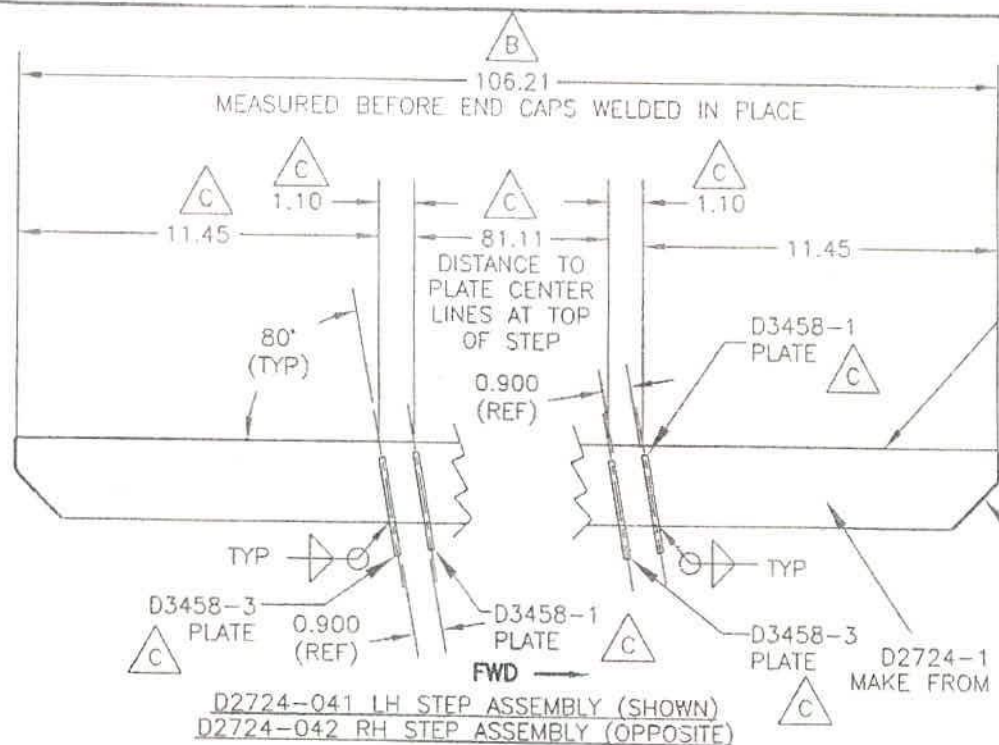
Job Completion



W 5/16/06

RELEASED
05-11-14

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS



— REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

D2724-041 LH STEP ASSEMBLY (SHOWN)
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

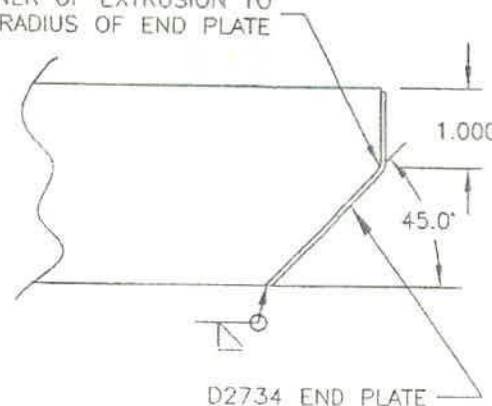
D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



D2734 END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
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FORI MALDEN, MA

REV. 6

Special Advertising Section

Sluiter

206L/407 STEP ASSEMBLY

NEW ISSUE

UPDATED WELD DETAIL
REVISED TOLERANCES

RE-DESIGN, ADD 03458-1/-3

1

10

CHECKED 14

REMOVED

DATE _____

A	
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97.12.04

98.10.19

C	

05.09.15

RE-DESIGN

ADD 03458-1/-3

1

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